

Date: Thursday, 04/09/2008 10:27:38 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR BRACKET RH
Job Number	: 41802		
Estimate Number	: 12340		
P.O. Number	:	Part Number	: D20134
This Issue	: 04/09/2008 S.O. No. :	Drawing Number	: D2013 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 41416	Material	:
Written By	:	Due Date	: 16/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 08.9.04</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 2.0447 f(s)/Unit Total : 20.4467 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M108 846

S/S 08/08/04 (10)

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

- 1-Punch as per template D2013-T3 and Dwg D2013
- 2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201
Identify as D2013-3.
- 4-Deburr as required

S/S 08/09/04 (10)

S/S 08/09/04 (10)

FF 08/09/08 (10)

SA 08/09/04 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/08 (10)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: W522

CP 08.09.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET RH

Job Number: 41802

Part Number: D20134

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

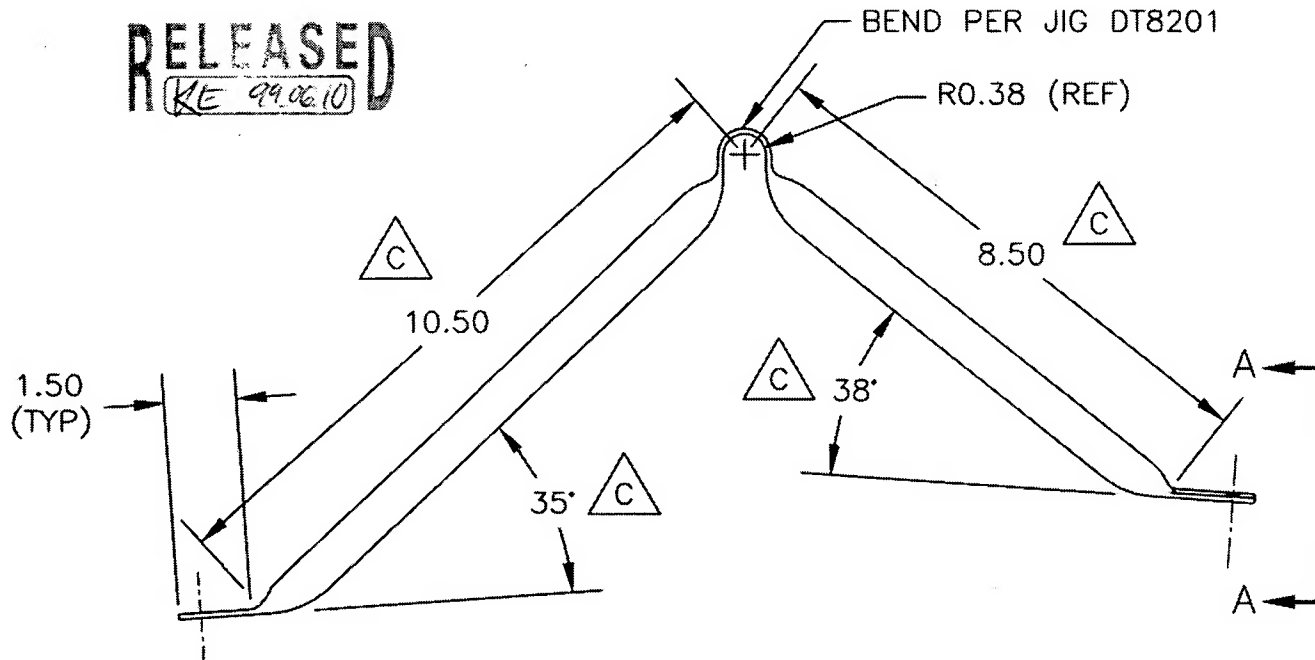
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

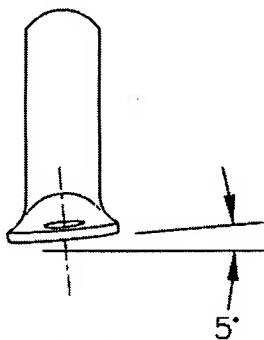
RELEASED
KE 99.06.10



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL $\phi 0.257$ (TYP)

0.400 (TYP)



VIEW A-A

CUT LENGTH: 23.25 INCHES

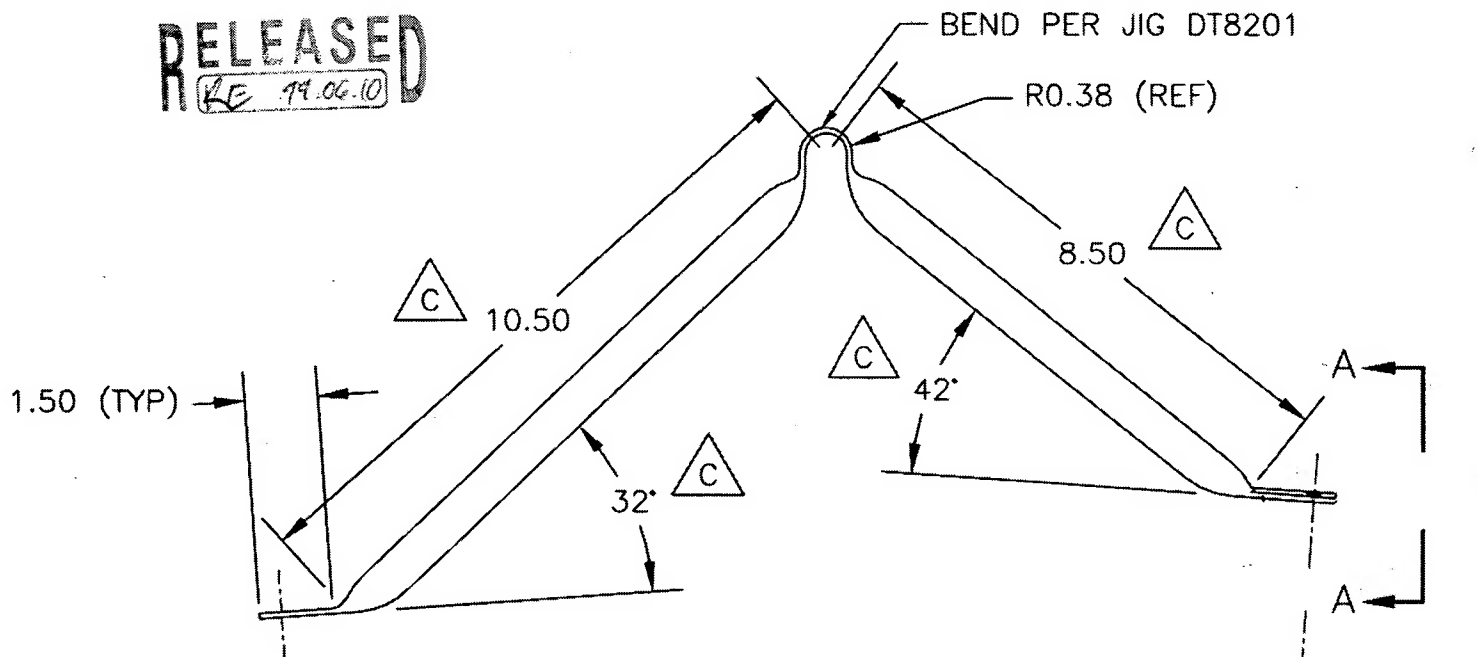
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DART

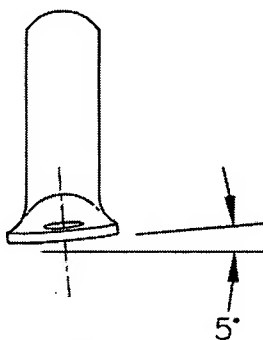


DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	AE	APPROVED	AE	REV. C
DATE	99.06.07	TITLE	MIRROR BRACKET	SHEET 1 OF 3
				SCALE
				NTS
	A	90.10.22	NEW ISSUE	
	B	94.06.15	REDRAWN	
	C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

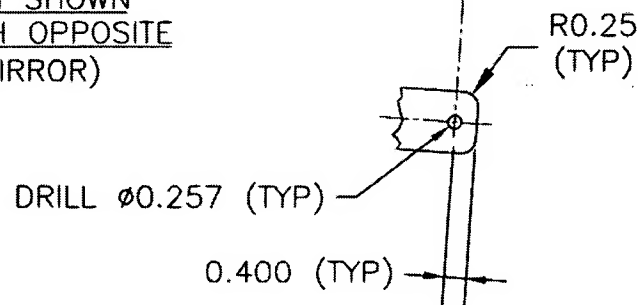
RELEASED
KE 19.06.10



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	REV. C
DATE	99.06.07	DRAWING NO.	D2013	SHEET 2 OF 3
TITLE	MIRROR BRACKET	SCALE	NTS	

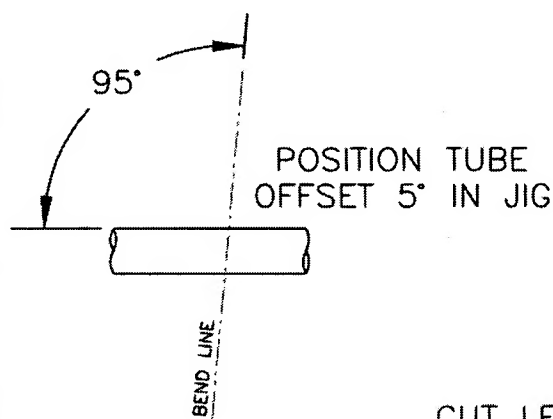
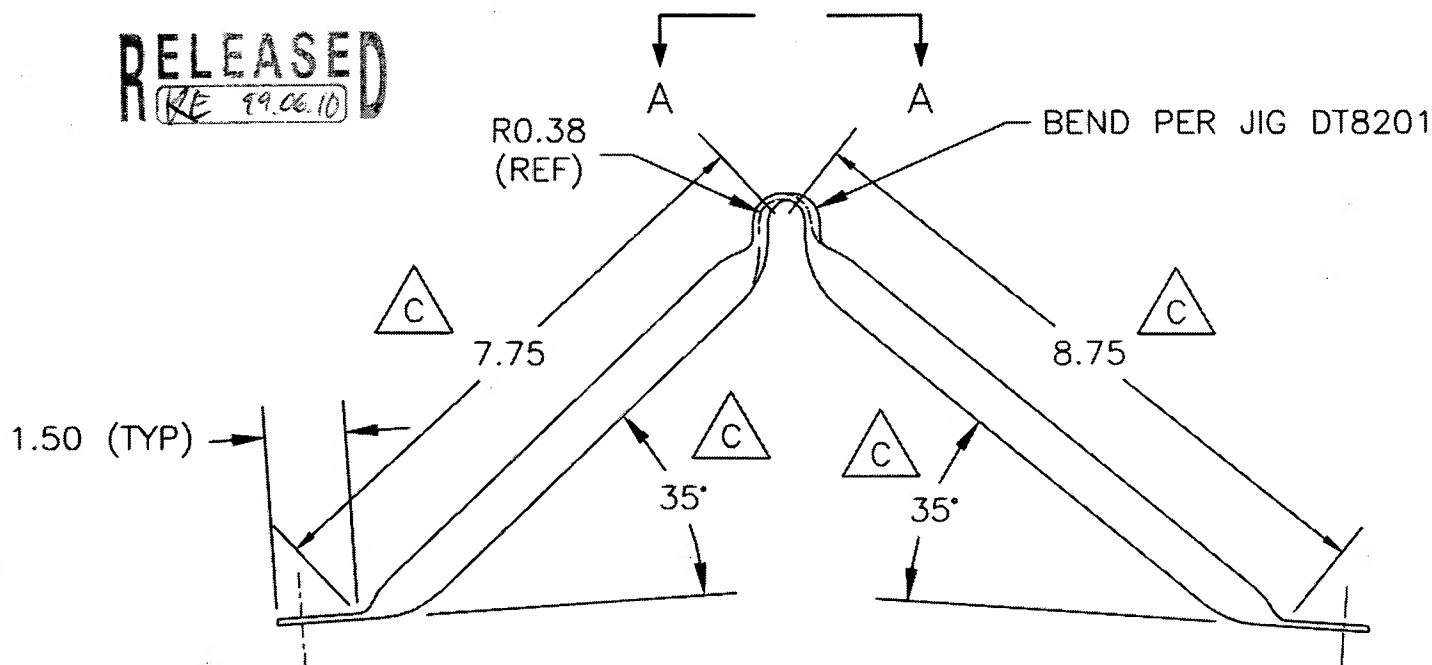
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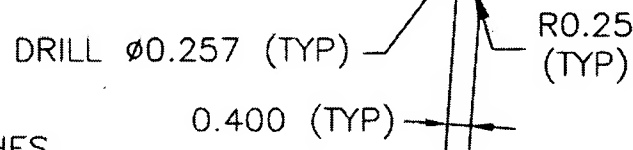
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RE 99.06.10

DART

ISSUED
COPY



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

VIEW A-A

DESIGN	JB	DRAWN BY	RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	RE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
		SCALE	NTS	

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